Work	Orde	r ID	61994

Wednesday, September 15, 2010 9:50:28 AM



Page 1

Insp.

Stamp

Item ID: D3763-3 Accept Setup Start **Revision ID:** Stop Tube Item Name: **Start Date:** 9/14/2010 Start Qty: 10.00 **Cust Item ID:** Required Date: 9/21/2010 Req'd Qty: 10.00 **Customer:** Reference: Run Start Date: 109-13 Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Reject **Tool ID** Tool # Plan Accept Reject **Work Center ID** Description Qty **Run Hours** Code Qty Number **Draw Nbr Revision Nbr** D3763 Rev B 100 0.00 DOOSAN LATHE 0.00 Doosan 1- Turn as per Folio FA751 Rev: At & Dwg D3763 Rev: S \quad \text{\textit{2-Deburr}} Doosan Lathe per dwg D3763 110 QC2- Inspect parts off machine FAI/FAIB 0.00 QC 0.00 Memo Quality Control

120

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

10/10/12

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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				* ***									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _					
Resolution:			Disposition: QA			osed:		Date: _					
NCR:			WORK ORDI	ER NON-CONFORMAN	ICE (NCR)							
DATE	CTED	Description of NC	Description of NC Corrective		Verifica				Approval				
DATE	STEP Description of NC Section A	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval Chief Eng	QC Inspector				
					1								

Work Order ID 61994

Wednesday, September 15, 2010 9:50:28 AM



Page 2

Item ID:

D3763-3

Accept

Setup Start

Stop

Revision ID:

Start Date:

Item Name:

Tube

9/14/2010

Start Qty: 10.00

Operation

Description

Req'd Qty: 10.00



Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Run

Start



Required Date: 9/21/2010

Date:_____

Identify as per dwg & Stock Location: 25

SPC (Y/N):

Date:

Stop

Sequence ID/ **Work Center ID**

130

Packaging

Memo

Run Hours

0.00

0.00

Set Up/

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Packaging

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

	•							
W/O:			WO	RK ORDER CHANG	EŜ			•
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	jory:	NCR: Yes	No DQA:	Date: _	
		solution:						
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC Corrective Action			on B	Verificatio	n Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
	1 1		i		I	1		

Picklist Print

Wednesday, September 15, 2010 9:50:32 AM

Work Order ID: 61994

Parent Item:

D3763-3

Parent Item Name: Tube



Start Date: 9/14/2010

Required Date: 9/21/2010

Page 1

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A 08-05-23 new issue

DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased	No	, <u> </u>	100	f	53.2071	0.109	1.147368			

6061-T6 Round Bar 1.250

Location

MAT013

Loc Code

53.20705 33.20705 20

Loc Qty

		—- 								
W/O:	T		WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	PROCEDURE CHANGE			,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Y	es N	o DQ	4 :	Date:	
	Re	esolution:	Disposition	:	_ QA: N/0	Clos	sed:		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORMA	ANCE (N	CR)				
DATE	STEP	Description of NC			ion B			ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Secti		Chief Eng	QC Inspector
										- -
l										
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DART AEROSPACE LTD	Work Order:	01994
Description: Tube	Part Number:	D3763-3
Inspection Dwg: D3763 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	le	Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.221	+0.005/-0.001	,221				
0.66	+/-0.030	.66				
1.31	+/-0.030	1.312				
0.66	+/-0.030	.66				
0.05 x 45°	+/-0.030 x +/-0.5°	105445				
Ø0.201	+0.005/-0.001	.201			_	
Ø1.010	+0.010/-0.000	1.615				
Ø1.16	+/-0.030	1.16				

Measured by:	Audited by:	AZ	Prototype Approval:	N/A
Date: 10.10.12	Date:	10/0/2	Date:	N/A

Rev	Date	Change	Revised	byιΛ	Approved
Α	08.09.04	New issue	KJ/DD	of the	

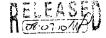
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W/O:	·		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
•											
Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	_ Date: _			
Resolution:											
NCR:			WORK ORE	DER NON-CONFORMA	NCE (NCR	1)					
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval		
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector		

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

D 2HOD COUN Ø0.201 Ø0.221 REF REF RETURNITO UNCONTRACTIONS С - 1.13 -ITEM NO. PART NUMBER DESCRIPTION QTY. (-041) D3763-3 TUBE D3763-1 FITTING 2

D3763-041 END FITTING ASSY



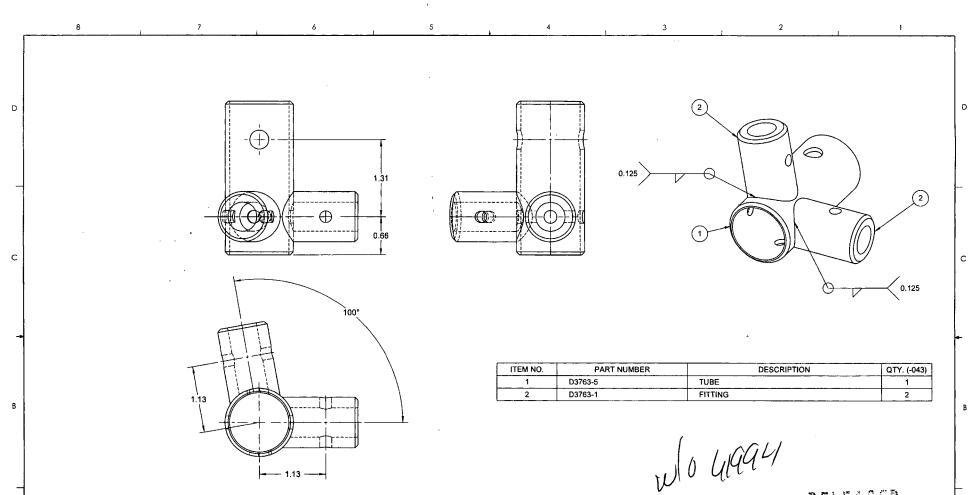
В	CHANG	E HOLES SIZE	, ADD -7 PART AND -045 ASSY	HS	08.06.23			
Α	NEW IS:	SUE		HS	08.06.04			
REV.			DESCRIPTION	BY DAT				
DESIG	N	HS	DART AEROSPACE LTD					
DRAW	N	HS		HAWKESBURY, ONTARIO, CANADA				
CHECK	HECKED A		DRAWING NO.	RE\				
MFG. A	APPR.	\mathbf{Z}	D3763		SHEET 1 OF			
APPRO	OVED		TITLE		SCAL			
DE AP	PR.	#	END FITTING		NT:			
DATE 08.06.23			COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIMATE AND COMPIDENTIAL AND IS SUPPLED ON THE EXPRESS COMDITION NOT TO BE USED FOR ANY DIMPOSE ON CONTEO OR COMMUNICATED TO ANY OTHER PERSON V WITTEN PERSONNER PEON DAY OF THE PERSON V WITTEN PERSONNER PEON PEON DAY OF THE PERSON V WITTEN PERSONNER PEON PEON PEON DAY OF THE PEON V WITTEN PERSONNER PEON PEON PEON DAY OF THE PEON V WITTEN PERSONNER PEON PEON PEON PEON PEON PEON PEON PEON					

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs
8) WELD: PER DART QSI 004

7

8

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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,						 			
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositi	on:	_ QA: N/C CI	osed:		Date: _	
NCR:		\	WORK ORI	DER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section B			cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
			:						
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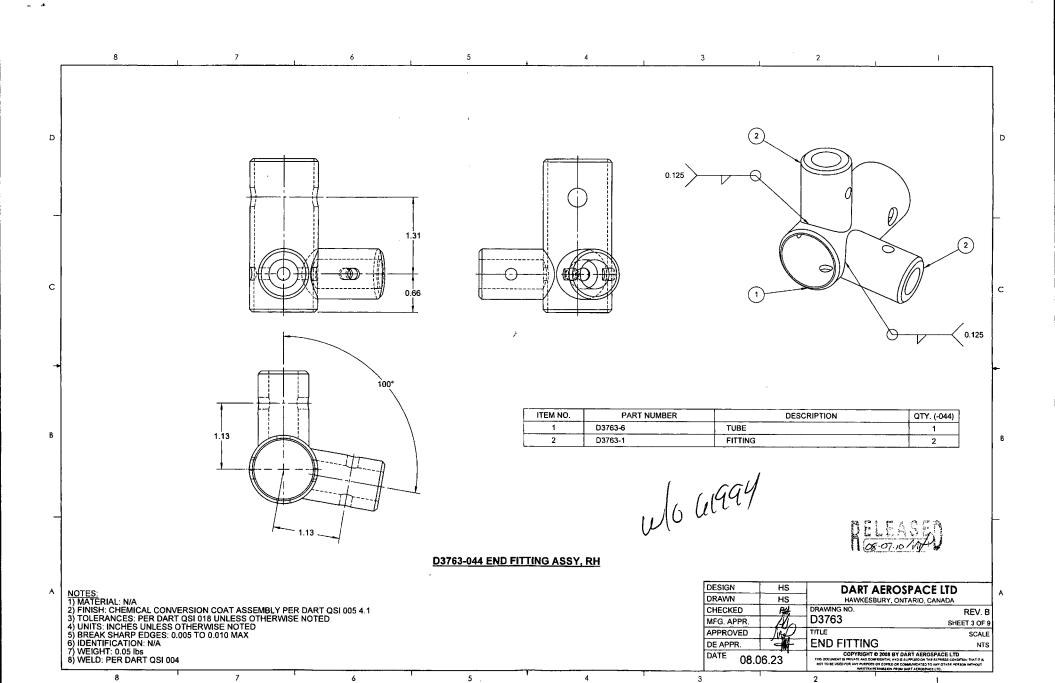


D3763-043 END FITTING ASSY, LH

A	NOTES: 1) MATERIAL: N/A 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4. 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: 0.05 Ibs 8) WELD: PER DART QSI 004

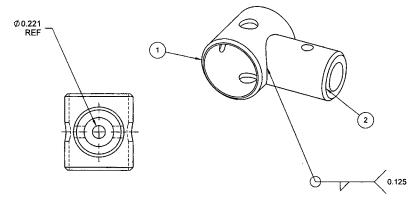
DESIGN	HS	DART AEROSP	ACE LTD		
DRAWN	HS	HAWKESBURY, ONTAF	RIO, CANADA		
CHECKED	RU	DRAWING NO.	REV. B		
MFG. APPR.	//h	D3763	SHEET 2 OF 9		
APPROVED	NAN	TITLE	SCALE		
DE APPR.		END FITTING	NTS		
DATE 08.0	06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIMATE AND COMPREHENLAND BS LUPPLED ON THE EXPRESS FOR DISTORMENT HAT IT B MOT TO BE USED FOR MAY MEROSS ON COMPRED ON COMMUNICATED TO ANY AITHFRE PERSON WITHOUT			

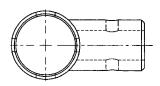
W/O:			WO	RK ORDER CHANG	ES						
DATE	STEP	PROCEDURE CHANGE				у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	•	PAR #:	Fault Cate	_ NCR:	NCR: Yes No DQA: Date:						
	R	esolution:	lution: Disposition:				QA: N/C Closed: Date: _				
NCR:			WORK ORDE	R NON-CONFORM	ANCE (I	NCR)					
DATE	STEP	Description of NC			tion B		Verification		Approval	Approval	
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section		Chief Eng	QC Inspector	
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W/O:			W	ORK ORDER CHANG	ES								
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Part No:		PAR #:	Fault Cat	tegory:	NCR: Yes No DQA: Date:								
						QA: N/C Closed: Date:							
NCR:		1	WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval					
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector					

Ø0.221 REF Ø0.323 REF D





1 D3763-7 TUBE 1	ITE	M NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
2 D3763-1 FITTING 1		1	D3763-7	TUBE	1
		2	D3763-1	FITTING	1

D3763-045 END FITTING ASSY

NOTES:
1) MATÉRIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

6) IDENTIFICATION: N/A
7) WEIGHT: 0.03 lbs
8) WELD: PER DART QSI 004

8

DESIGN	HS	DART AEROSP	ACE LTD		
DRAWN	HS	HAWKESBURY, ONTAF			
CHECKED	PS	DRAWING NO.	REV. B		
MFG. APPR.	1	D3763	SHEET 4 OF 9		
APPROVED	JW.	TITLE	SCALE		
DE APPR.	-111	END FITTING	NTS		
DATE 08.0	06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENTS PARATIC AND COMPLETIAL AND IS EUPRATIC ON THE EXPRESS CONCITION THAT IT IS NOT TO SE USED FOR ANY PARADIC ON COMPLET OR COMPLETED TO			

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								Prod Mgr	,	
Part No:		PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A:	Date:		
		solution:	Disposit	_ QA: N/C C	QA: N/C Closed: Date:					
NCR:		,	WORK OR	DER NON-CONFORMA	NCE (NCI	R)				
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval	
·	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date		ion C	Chief Eng	QC Inspector	

D Ø0.50 THRU R0.580 ∠0.06 x 45* CHAMFER ALL AROUND Ø0.860^{+0.000} С - 1.090 -Ø0.201 🔊 -0.05 X 45° CHAMFER --- 0.545 -- **D3763-1 FITTING** DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DESIGN HS NOTES: 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R) DRAWN HS DRAWING NO. CHECKED REV. B (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs D3763 MFG. APPR. SHEET 5 OF 9 TITLE APPROVED SCALE **END FITTING** DE APPR. NTS

5

7

8

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DATE

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08.06.23

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Part No:			W	ORK ORDER CHANG	ES				· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		PAR #: Fault Category:									
		esolution:	lution: Disposition:			C Clos	sed:	Date:			
NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP Description of NC Section A		Corrective Action Initial Action Descript		Sign &		Verification Section C		Approval Chief Eng	Approval QC Inspector	
			Chief Eng	Chief Eng		Date				,	

